

ABSTRACT OF THE DISCLOSURE

[0091]

The present invention provides method of fabricating components having internal teeth and rolling machine thereof, enabling large deformation at main rolling step omitting broaching step and step using gear shaper. A container having toughness against internal pressure as high as that of cold forging is provided instead of gripping mechanism of a cylindrical material. A cylindrical material is inserted into the rotatably driven container in aligned manner. A rotatably driving rolling tool is acted on the inner side to press the cylindrical material and distance between tool rotational shaft and container rotational axis is sequentially changed to successively grow tooth profile. A component having internal teeth filling the container is obtained by enlarging outer diameter by spreading. It is desirable to provide in advance the same number of concave grooves as that of internal teeth to be formed, at equal intervals on an inner circumferential face of the cylindrical material.